

Date: Wednesday, 10/06/2009 9:58:14 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKID TUBE ASSEMBLY
 Job Number : 48449A
 Estimate Number : 10023
 P.O. Number :
 This Issue : 10/06/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D205634041
 First Issue : // Type : SKIDTUBES Drawing Number : D2580 REV D
 Previous Run : 48448A Drawing Revision : D
 Material :
 Due Date : 26/06/2009 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : Julie Dawson 06.10
 Comment : Est Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 Est Rev. O 06.02.28 Added paperwork EC
 Est Rev:P 07-07-09 SS Wearplates & Gaskets JLM
 Est Rev:Q 09-03-19 rev.f as per IIN DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A *[Signature]*

2.0 D25801 Drilling Detail, 205 Skidtube



X Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

205 Skidtube bent detail

B48455 *[Signature]* 09-06-12

3.0 BENDING BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

[Signature] 09-06-12

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends

2-Prepare tube for welding, remove alodine as required.

3-Scribe Batch # on the aft end inside of tube

[Signature] 09-06-12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/06/15 (H)

6.0

D25763

Step (maching detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------|
| 1 | D2576-3 | Step | BE 43504 |

BE 09/06/15

7.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------|
| 20 | D2579 | Spacers | BE 46956 |

BE 09/06/15

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

1111679

BE 09/06/15

3-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

1111679

BE 09/06/15

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

DP 9-6-16

5-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

7-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

MB
09-06-16 (C)

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Job Number: 48449A

Part Number: D205634041

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/06/16 (X)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/06/16 (X)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

UMP 09/06/16 (X1)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 8:30 AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:00 AM

09-06-17 (X)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BF 09-06-17 (D)

14.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: B42343

UMP 09/06/18

15.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M100188

UMP 09/06/18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: m109632

UMD 09/06/18

17.0

ALS71032130

Insert



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Insert

* Batch: m110511

UMD 09/06/18

18.0

AN3C4A

BOLT



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

BOLT

* Batch: m111819 (X28)

*m112082 (X22)

MD 09/06/18

19.0

AN960C10L

washer



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

washer

* Batch: m111808

UMD 09/06/18

20.0

D356613

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B48166

UMD 09/06/18

21.0

D35665

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B48137

UMD 09/06/18

22.0

D35661

Gasket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: B48165

UMD 09/06/18

| W/O: | | WORK ORDER CHANGES | | | | | |
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Job Number: 48449A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

D356413

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: B46183

UMD 09/06/18

24.0

D356411

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: B47012

UMD 09/06/18

25.0

D35649

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: B47316

UMD 09/06/18

26.0

D35645

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: B48164

UMD 09/06/18

27.0

D25943

O-Ring, 205 Skidtube



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

O-Ring

Batch: B29908

UMD 09/06/18

28.0

D25941

Plug, 205 Skidtube



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Plug

Batch: B43884

UMD 09/06/18

29.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R

Sikaflex-291

m14557

UMD

09/06/18

(XV)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Sikaflex expire date: 10/01

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 m11557

Sikaflex expire date: 10/01

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: m111013

umd
09/06/18

umd 09/06/18

30.0

QC5

INSPECT WORK TO CURRENT STEP



8 09/06/19 @



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

31.0

PACKAGING 1

PACKAGING RESOURCE #1



9/6/19



10

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location:

PPP Rev: PPP 48449

510

32.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 09/06/22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART**RELEASED**
07-06-28 #

| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2580 | REV. D SHEET 1 OF 3 |
| DATE 07.02.27 | | TITLE 205 SKIDTUBE ASSEMBLY | SCALE NTS |
| A | 96.09.16 | NEW ISSUE | |
| B | 96.12.02 | AS MANUFACTURED | |
| C | 98.08.26 | REDRAWN, INCLUDED DEO 9094/9097 | |
| D | 07.02.27 | CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183 | |

| QTY -041 | QTY -045 | Part Number | Description |
|-------------|-------------|---|-------------------|
| X | | D2580-041 | SKIDTUBE ASSEMBLY |
| | X | D2580-045 | SKIDTUBE ASSEMBLY |
| | | | |
| 1 | 1 | D2500-1-190 | EXTRUSION |
| 1 | 1 | D2576-3 | STEP |
| 20 | 24 | D2579 | CROSS BOLT SPACER |
| 16 | 16 | D2594-1 | PLUG |
| 16 | 16 | D2594-3 | O-RING |
| 1 | 1 | D2596 | 205 WEB |
| 1 | 1 | D2855 | AFT CAP |
| 1 | 1 | D3564-5 | WEARSHOE |
| 1 | 1 | D3564-9 | WEARSHOE |
| 1 | 1 | D3564-11 | WEARSHOE |
| 1 | 1 | D3564-13 | WEARSHOE |
| 2 | 2 | D3566-1 | GASKET |
| 1 | 1 | D3566-5 | GASKET |
| 1 | 1 | D3566-13 | GASKET |
| | | | |
| 50 | 50 | ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130 | INSERT |
| 50 | 50 | AN3C4A | BOLT |
| 2 | 2 | AN3-5A | BOLT |
| 50 | 50 | AN960C10L | WASHER |
| 2 | 2 | AN960JD10L | WASHER |

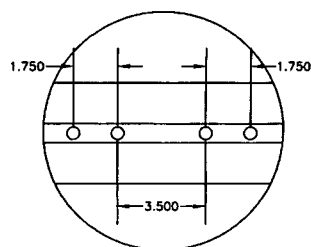
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200" COP COPY IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241. RETURN TO ENGINEERING FOR CONTROLLED COPY
SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 48449A
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

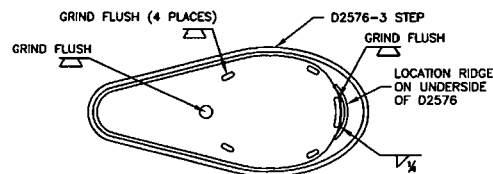
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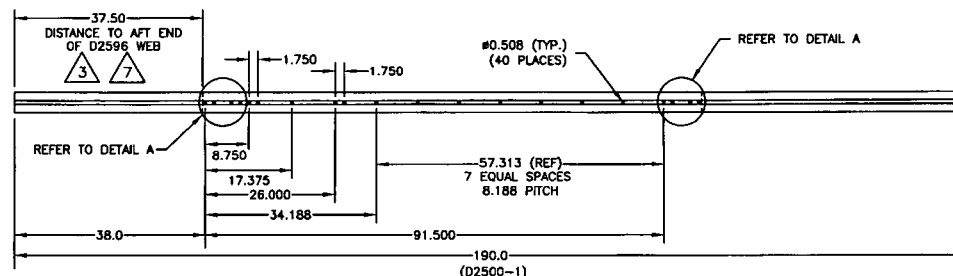
DETAIL A
SCALE 5:24



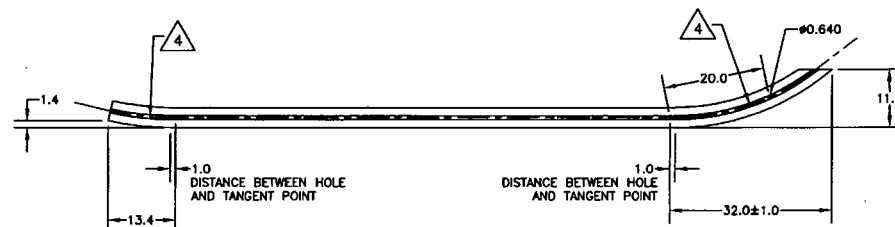
DETAIL B
SCALE 5:24



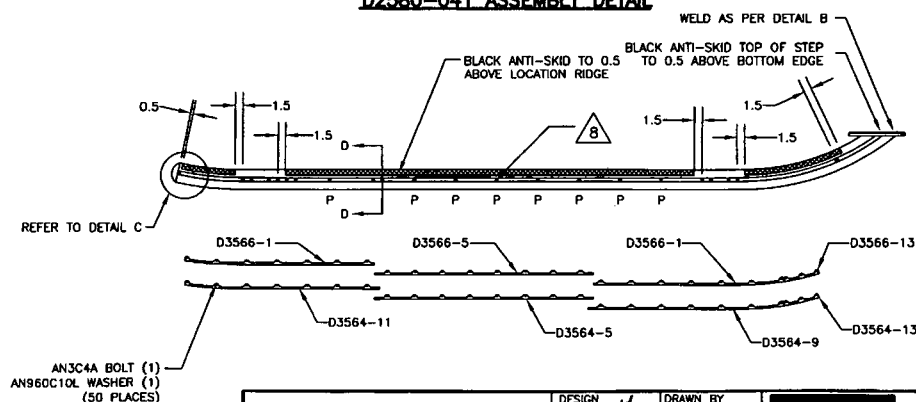
D2580-1 DRILLING DETAIL



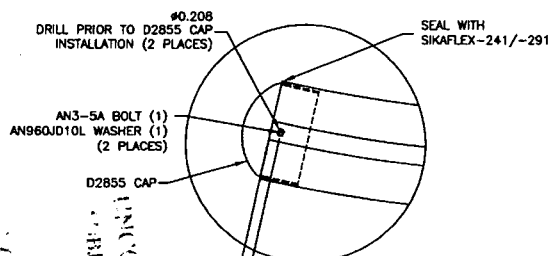
D2580-1 BENDING AND CUTTING DETAIL



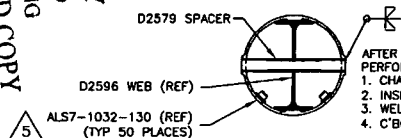
D2580-041 ASSEMBLY DETAIL



DETAIL C
SCALE 5:24



SECTION D-D
SCALE 5:24



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D2579 SPACER (20 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C-BORE D2579 SPACER TO #0.437 X 1.00 DEEP

D2580-041 NOTES

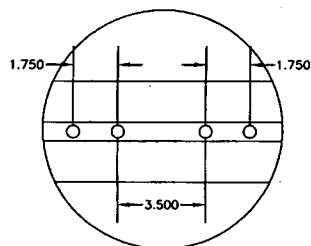
- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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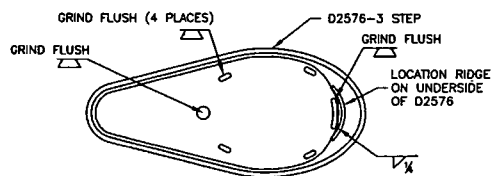
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|---------|----------|-----------------------|---------------------|
| DESIGN | DRAWN BY | DART | DART AEROSPACE LTD. |
| CHECKED | APPROVED | DRAWING NO. | REV. D |
| DATE | 07.02.27 | D2580 | SHEET 2 OF 3 |
| | | TITLE | SCALE |
| | | 205 SKIDTUBE ASSEMBLY | 1:24 |

DETAIL F
SCALE 5:24

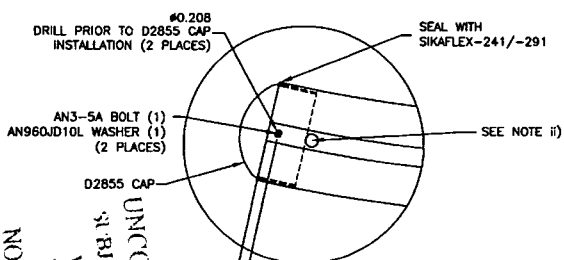


DETAIL F
SCALE 5:24

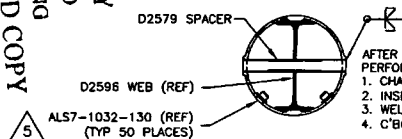


RELEASED
07.06.28

DETAIL G
SCALE 5:24

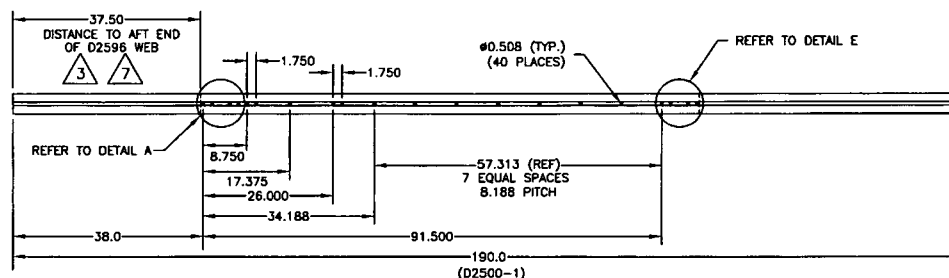


SECTION H-H
SCALE 5:24

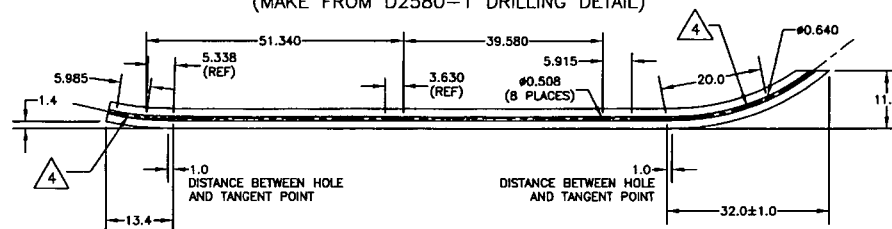


AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

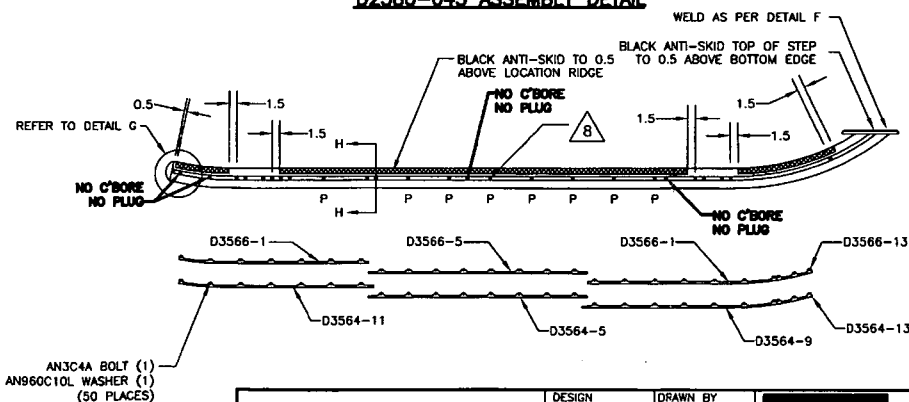
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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| | | | |
|------------------|--------------------------------|----------------------|---|
| DESIGN RH | DRAWN BY RH | DART | DART AEROSPACE LTD. WARRICKSURY, ONTARIO, CANADA |
| CHECKED H | APPROVED H | DRAWING NO. D2580 | REV. 0 SHEET 3 OF 3 |
| DATE 07.02.27 | TITLE 205 SKIDTUBE ASSEMBLY | SCALE 1:24 | |

NO. 195

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 46799A
Part number: D205 634041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:  pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier P. Elliott Date of Test Coupon 09-04-08

Welder Barclay Elliott Date of Test Coupon 09/04/08

The above named individual is qualified in accordance with AWS D17.1.2001 to weld